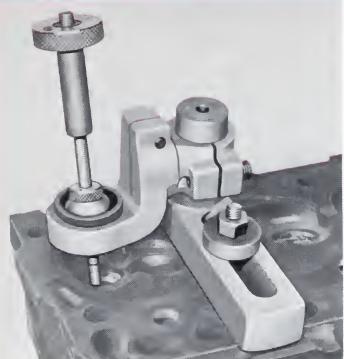


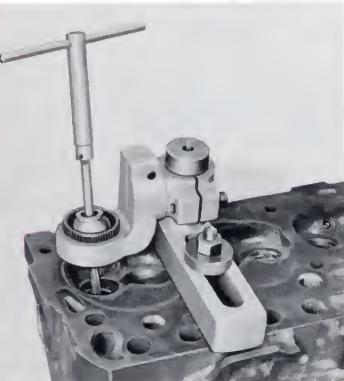
VALVE GUIDE REAMING SETS



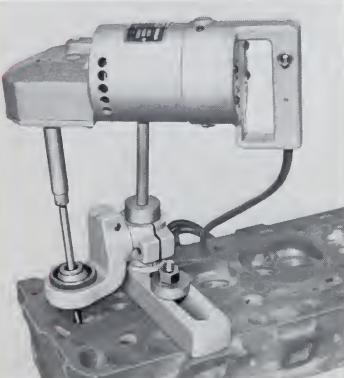
Aligning guide assembly with original valve guide bore using a Lee self-expanding pilot and 3/8" aligning bushing.



Inserting bushing and reamer in guide assembly after aligning guide assembly with valve guide bore.



The reamer is guided true with reaming bushing. T-wrench is used for hand operation.



The R55B power drive is adaptable as a power unit for reaming operation.

The K. O. Lee valve guide reaming tools are designed to service late model engines which have valve guides cast as part of the cylinder head. These tools can be used to install oversize stem valves or replaceable valve guides.

Installing Oversize Stem Valves

This is accomplished by reaming out the valve guide for oversize stem valves. Most of the engines and valve manufacturers now offer at least three sizes of oversize valves.

The K. O. Lee reamer guide provides a true alignment with original guide bore using Lee self-expanding pilots. The reamer is held rigid with reaming bushing during reaming operation. Simple to operate and extremely accurate. Sets available described on page 2.

Installing Replaceable Valve Guides

When old valves are still serviceable, it is more economical to install replaceable valve guides. Roughing and finishing reamers used with the K. O. Lee reamer guide, accurately cut the recess for a replaceable guide. A complete listing of the replaceable valve guides, roughing and finishing reamers, and expanding pilots available are listed on page 3. Guide service data on back page.



OPERATING INSTRUCTIONS

FOR INSTALLING OVERSIZE STEM VALVE

Clean out valve guide hole with an H1000 series Solid Valve Guide Reamer. Position self-expanding pilot in valve guide with P61 Pilot Wrench. Loosen all swivels of reamer guide assembly and install pilot aligning bushing in universal ball. Position unit on expanding pilot. Rotate unit until clamp rod can be aligned to stud hole. Tighten clamp rod with fingers until base is held firmly to block. Tighten swivels and ball socket. Loosen clamp rod, reposition and lock to block as shown in photo number 1. (NOTE: To attain extreme accuracy, it may be necessary to loosen and tighten swivels of reamer guide assembly several times.)

Remove expanding pilot and aligning bushing. Position piloted reamer in valve guide. Install reaming bushing on top shank of reamer as shown in photo number 2.

In photo number 3, Reaming Bushing is shown in position in universal ball, providing true alignment. Unit is now ready for reaming. T-wrench is used for hand operation.

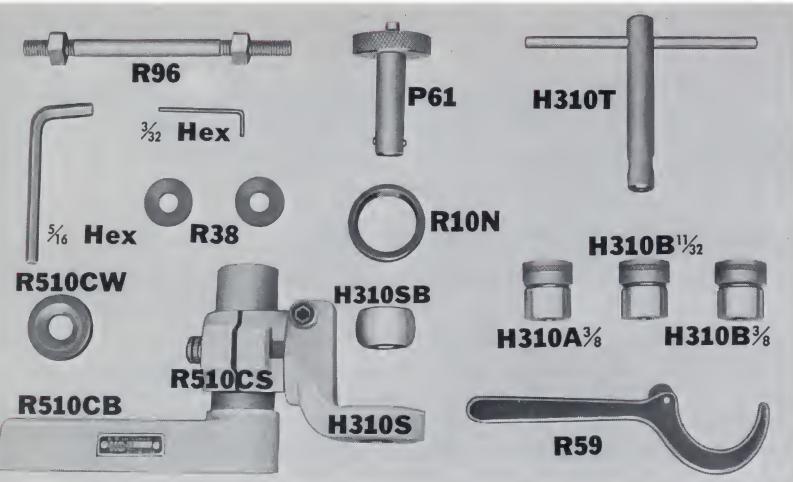
Power Drive R55B, adaptable as a power unit, is shown in photo number 4. Available with 115 or 230 volt universal motor.

FOR INSTALLING REPLACEABLE VALVE GUIDES

The same procedure is used when installing replaceable valve guides. Let us assume that the replaceable guide you wish to install has an O.D. of $\frac{1}{2}$ ". In photo 2, the H8494 roughing reamer would be used with the H310B $\frac{1}{16}$ " bushing. The roughing reamer operation would be followed with the H3500 Carbon Steel or H7500 High Speed Steel finishing reamer using the same bushing, as all roughing and finishing reamers have a $\frac{1}{8}$ " shaft. As power is required for these reaming operations a $\frac{1}{2}$ " drill is recommended. All thin wall valve guides should be installed with some type of press. O.D. OF VALVE GUIDE AND HOLE MUST BE LUBRICATED BEFORE ATTEMPTING TO INSTALL GUIDE. If necessary to ream I.D. of guide after installation, use H1000 series solid reamers shown on page 3.

K. O. LEE VALVE GUIDE REAMING SETS

H300 Basic Valve Guide Reaming Set



This basic set used with any of the H2000 series Valve Guide Reamers and sets listed on page 3, provides upper guide for reamer. Enables mechanic to get a true hole, not bell shaped. Self Expanding Pilots required are listed in special valve guide reaming sets and on page 3.

SET CONSISTS OF

H1310 Reamer Guide Assembly	26.00
H310S Swivel Head	
H310SB Swivel Ball	
R510CB Base	
R510CS Univ. Swivel	
R510CW Special Washer	
R10N Guide Nut	
5/16 Hex Wrench	
H310A 3/8" Aligning Bushing	3.90
H310B 11/32" Reaming Bushing	3.90
H310B 3/8" Reaming Bushing	3.90

Each Reaming Bushing will take care of all oversize reamers in its size.

H310T T-Wrench	2.60
P61 Pilot Wrench	4.90
R38 Two Washers	.20
R59 Spanner Wrench	3.00
R96 Clamp Rod	.60
3/32 Hex Wrench	.20
H505B Metal Box	20.00

COMPLETE SET 69.20

WITH THE ADDITION OF A SMALL NUMBER OF PARTS THIS SET CAN BE USED AS A BASIC RESEATER SET. REFER TO K. O. LEE RESEATER CATALOG SHEET.

The H300 Basic Valve Guide Reaming Set can be used to install oversize stem valves or to install replaceable valve guides. To install oversize stem valves, select the proper oversize H2000 SERIES reamer, and self expanding pilot from the listing of accessories on page 3.

To install replaceable valve guides, select the correct self expanding pilot for alignment, and roughing and finishing reamers to cut the O.D. size of the replaceable guide.

The reaming sets listed below, though set up for installing oversize valves, can be used to install replaceable guides with addition of roughing and finishing reamers, H310G adapter and H310B $\frac{1}{8}$ reaming bushing.

R55B Power Drive

AVAILABLE FOR
H300, H302, H306 AND H307 SETS

\$95.00

H310D Adapter 1/4" Square	3.60
H310E Adapter 9/32" Square	3.60
H310F Adapter 21/64" Square	3.60

H304 Universal Valve Guide Reaming Set

This set will service Ford, Mercury, Lincoln, Chevrolet, Pontiac .003", .015" and .030" oversize valves. Chrysler, DeSoto, Dodge, Plymouth .005", .015" and .030" oversize valves.

SET CONSISTS OF

H310 Reamer Guide Assembly	26.00
H310A 3/8" Aligning Bushing	3.90
H310B 11/32" Reaming Bushing	3.90
H310B 3/8" Reaming Bushing	3.90

Each Reaming Bushing will take care of all oversize reamers in its size.

H310T T-Wrench	2.60
H2347 Reamer 11/32"+.003"	4.60
H2359 Reamer 11/32"+.015"	4.60
H2374 Reamer 11/32"+.030"	4.60
H2376 Reamer 3/8"+.001" (.376")	4.60
H2379 Reamer 3/8"+.005"	4.60
H2388 Reamer 3/8"+.013" (.388")	4.60
H2389 Reamer 3/8"+.015"	4.60
H2403 Reamer 3/8"+.028" (.403")	4.60
H2404 Reamer 3/8"+.030"	4.60
P61 Pilot Wrench	4.90
P84L 11/32" Self Expanding Pilot	6.00
P85L 3/8" Self Expanding Pilot	6.00
P85RL 3/8"+.015" Self Expand. Pilot	6.00
R38 Two Washers	.20
R59 Spanner Wrench	3.00
R96 Clamp Rod	.60
3/32 Hex Wrench	.20
H505B Metal Box	20.00

COMPLETE SET 134.60

H306 Special Valve Guide Reaming Set

FOR FORD, MERC., LINC., CHEV.
WITH 11/32" VALVES

SET CONSISTS OF

H300 Basic Valve Guide Set	69.20
H2347 Reamer 11/32"+.003"	4.60
H2359 Reamer 11/32"+.015"	4.60
H2374 Reamer 11/32"+.030"	4.60
P84L 11/32" Self Expanding Pilot	6.00
P84RL 11/32"+.015" Self Exp. Pilot	6.00

COMPLETE SET 95.00

Important Notice

To service the above engines with 3/8" or 7/16" oversize valves, the following tools must be added.

FOR 3/8" VALVES	
H2376 Reamer 3/8"+.001" (.376")	4.60
H2388 Reamer 3/8"+.013" (.388")	4.60
H2403 Reamer 3/8"+.028" (.403")	4.60
P85L 3/8" Self Expanding Pilot	6.00
P85RL 3/8"+.015" Expand. Pilot	6.00

FOR 7/16" VALVES	
H2441 Reamer 7/16"+.003" (.441")	4.60
H2453 Reamer 7/16"+.015" (.453")	4.60
P86 7/16" Self Expanding Pilot	5.50
P86RM 7/16"+.015" Expand. Pilot	6.00

H307 Special Valve Guide Reaming Set

FOR PLYMOUTH, DODGE,
DeSOTO, CHRYSLER

SET CONSISTS OF

H300 Basic Valve Guide Set	69.20
H2379 Reamer 3/8"+.005"	4.60
H2389 Reamer 3/8"+.015"	4.60
H2404 Reamer 3/8"+.030"	4.60
P85L 3/8" Self Expanding Pilot	6.00
P85RL 3/8"+.015" Self Expand. Pilot	6.00

COMPLETE SET 95.00

Important Notice

To service Ford and Chevrolet engines with 7/16" oversize valves the following tools must be added to H302 and H304 Valve Guide Reaming Sets.

H2441 Reamer 7/16"+.003" (.441")	4.60
H2453 Reamer 7/16"+.015" (.453")	4.60
P86 7/16" Self Expanding Pilot	5.50
P86RM 7/16"+.015" Expand. Pilot	6.00

H305 Universal Valve Guide Reaming Set

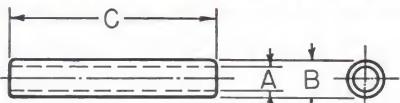
SET CONSISTS OF

H304 Universal Set	134.60
H310D Adapter 1/4" square	3.60
H310E Adapter 9/32" square	3.60
R55B Power Drive	55.00

COMPLETE SET 236.80

VALVE GUIDE REAMING ACCESSORIES

Replaceable Valve Guides



Popularity Rating	Part No.	I.D.	O.D.	C Lgth.	Application
23	G1240 .250	.439	2 1/8		Briggs-Stratton, Clinton
	GL1240 .250	.439	2 1/8		
28	GL1275 .276	.498	2 1/8		Special Application
22	GL1276 .2756	.397	1 1/8		36 H.P. Volkswagen
10	G1310 .3115	.439	1 1/8		Wisconsin with Replaceable Guides and Ford Falcon and Comet
16	G1311 .3115	.439	2 1/8		Wisconsin, AGN, AHH, VG4D
19	GL1315 .3150	.475	2 1/8		40 H.P. Volkswagen
26	G1316 .3115	.502	1 1/2		Waukesha ICK Exh.
27	G1317 .3125	.502	1 1/8		Waukesha ICK Int.
25	GL1347 .3427	.502	3 1/4		GMC 305 Engine, Exhaust
7	G1345 .3435	.502	2 1/4		Int., Chev. 265, 383, 327, Chev. II Both; Ford 272, 292, 312 with 1/4 Exh.; 6 cyl. Rambler Alum. Eng. Both; Pontiac 61-63 Int.
	GL1345 .3435	.502	2 1/4		
2	G1340 .3435	.502	2 1/8		Exh., Chev. 265, 283, 327; Ford Int., 239, 256, 302, 332; Int. 55-59 272, 292, 312; GMC 336 Int.; Pont. 61-63 Exh.
1	G1342 .3435	.502	2 1/2		Ford 6 cyl. Both; 1960-62 272, 292 Int.; 1955-59 272, 292, 312 Exh.; GMC 288, 316, 347, 305 Int.; Pontiac 1955-60 Int.; Buick Spec. 6 Both
4	G1343 .3435	.502	2 1/8		Exhaust, Ford, Mercury, Lincoln 239, 256 Eng.; GL1343 .3435
3	G1344 .3435	.502	2 1/8		GMC 288, 316, 347, 305 Intake; Pontiac 1954-60, Exhaust
17	GL1346 .3435	.518	2 1/8		All Corvairs
18	G1341 .3455	.6578	2 1/8		Oldsmobile, Intake, 54-60
	GL1341 .3455	.6578	2 1/8		With Replaceable Valve Guides
5	G1373 .3735	.502	2 1/8		Ford, Merc., Linc., 322, 352, 406 Both; Exh. 383, 430; Int. 302, 332 with 1/4 Exh.
	GL1373 .3735	.502	2 1/8		
9	G1374 .3735	.502	2 1/8		Valiant and Lancer, 170, 225, Both
	GL1374 .3735	.502	2 1/8		
11	G1375 .3735	.502	2 1/8		Lincoln, Mercury 283, 383, 430 Engines, Intake; GMC 336 Exhaust
	GL1375 .3735	.502	2 1/8		
6	G1370 .3745	.502	2 1/8		Plymouth, Dodge, Chrysler Engines 260, 270, 315, 325 Both
	GL1370 .3745	.502	2 1/8		
12	G1376 .3745	.502	2 1/8		Chry. Corp. Eng. 277, 301, 318, Exh.; 350, 354C-75, 361, 383, 413 Both; Chev. 348, 409 Int.
	GL1376 .3745	.502	2 1/8		
8	G1371 .3745	.502	2 1/8		Chry. Engs. 277, 301, 318, Int.; D500 (325) Dart, Both; Chev. 348, 409 Exh.
	GL1371 .3745	.502	2 1/8		
14	G1377 .3745	.502	2 1/8		GMC 351, 401, 702 Intake; Wisconsin VR4D, VR4; Chry. D500 (354) Both
	GL1377 .3745	.502	2 1/8		
20	G1372 .3745	.6263	2 1/8		Buick, 1954-62 With Replaceable Guides
	GL1372 .3745	.6263	2 1/8		
21	G1390 .3973	.6578	2 1/8		Oldsmobile, Exhaust, 1954-60 With Replaceable Guides
	GL1390 .3973	.6578	2 1/8		
15	G1431 .437	.627	2 1/2		Exhaust, Ford, 272, 292, 302, 332, Heavy Duty Engines with 1/4 Exhaust
	GL1431 .437	.627	2 1/2		
13	G1430 .437	.627	2 1/2		Ford, Chevrolet and Lincoln with 1/4 Exhaust
	GL1430 .437	.627	2 1/2		1955-60 Ford 401, 477, 534 Engines, Both
24	GL1432 .437	.627	3 1/4		GMC 351, 401, 702, Exhaust

The G Series Guides are Cast Iron and list at .50 each. The GL Guides are "Lee-Alloy", a dense longer wearing alloy metal. The GL Series Guides list at .80 each.

Tools to Install Valve Guides

H310B $\frac{1}{16}$ " Reaming Bushing 3.90
H310G 1/2" Round Drive for 1/2" Electric Drill 3.60

The H310G Drive and the H310B $\frac{1}{16}$ " Reaming Bushing are used with roughing and finishing reamers.

We recommend a 1/2" drill for power, as a power unit with about 400 R.P.M. is required. The roughing reamer operation would be followed with a carbon steel or high speed steel finishing reamer. Both types are listed below. We recommend the high speed steel finishing reamer for volume production.

Reamers to Install 1/8" O.D. Guide

H3437 Finishing Reamer, Carbon Steel 5.00
H7437 Finishing Reamer, High Speed Steel 13.50
H8432 1/4" Roughing Reamer, High Speed Steel 15.50
1/4" Piloted End For 1/4" I.D. Valve Guide
H8432 5/16" Roughing Reamer, High Speed Steel 15.50
5/16" Piloted End For 5/16" I.D. Valve Guide

Reamers to Install 1/2" O.D. Guide

H3500 Finishing Reamer, Carbon Steel 5.00
H7500 Finishing Reamer, High Speed Steel 13.50
H8494 11/32" Roughing Reamer, High Speed Steel 15.50
11/32" Piloted End For 11/32" I.D. Valve Guide
H8494 3/8" Roughing Reamer, High Speed Steel 15.50
3/8" Piloted End For 3/8" I.D. Valve Guide

Reamers to Install 5/8" O.D. Guide

H3625 Finishing Reamer, Carbon Steel 5.00
H7625 Finishing Reamer, High Speed Steel 13.50
H8619 7/16" Roughing Reamer, High Speed Steel 15.50
7/16" Piloted End For 7/16" I.D. Valve Guide

Solid Piloted Reamers

H2000 SERIES

Special length reamers for use with Lee valve guide reaming sets. Reamers Each \$4.60 — Reaming Bushings Each \$3.90 Each Bushing will guide the standard size reamer plus all oversizes of its stamped size. For example, the H310B 5/16" Bushing will guide the H2317, H2327, H2342 Reamers.

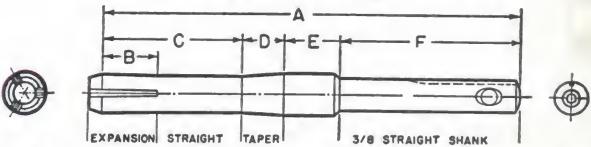
Reamer	Size	Bushing	Reamer	Size	Bushing
H2315	5/16 +.003	H310B 5/16	H2377	7/8 +.003	H310B 7/8
H2317	11/16 +.004	H310B 11/16	H2379	9/8 +.005	H310B 9/8
H2328	3/4 +.015	H310B 3/4	H2384	3/8 +.010	H310B 3/8
H2342	5/16 +.030	H310B 5/16	H2388	7/8 +.013	H310B 7/8
H2347	11/32 +.003	H310B 11/32	H2389	3/8 +.015	H310B 3/8
H2349	11/32 +.005	H310B 11/32	H2394	7/8 +.020	H310B 7/8
H2354	11/32 +.010	H310B 11/32	H2403	3/8 +.028	H310B 3/8
H2359	11/32 +.015	H310B 11/32	H2404	7/8 +.030	H310B 7/8
H2364	11/32 +.020	H310B 11/32	H2441	5/16 +.003	H310B 5/16
H2374	11/32 +.030	H310B 11/32	H2453	7/8 +.015	H310B 7/8
H2376	7/8 +.001	H310B 7/8	H2468	7/8 +.030	H310B 7/8

K. O. LEE OVERSIZE VALVE GUIDE HAND REAMING SETS

H2000 Reamer Set, for Ford, Merc., Chev. 16.00 Includes H2347, 11/32" + .003"; H2359, 11/32" + .015"; H2374, 11/32" + .030" Reamers.

H2002 Reamer Set, for Chrysler Corp. Engs. 16.00 Includes H2379, 3/8" + .005"; H2389, 3/8" + .015"; H2404, 3/8" + .030" Reamers.

Self Expanding Pilots

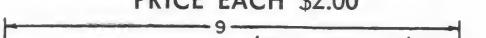


Part No.	Pilot Size	A	B	C	D	E	F	Price
P95	1/4	4 5/8	3/4	1 1/8	7/8			2 1/8
P83L	5/16	6 1/4	7/8	1 1/4	3/4	1/2	3 1/4	6.00
P83RL	5/16 +.015	6 1/2	1 1/8	2	1 1/4			6.00
P84L	11/32	6 1/4	7/8	1 1/4	3/4	1/2	3 1/4	6.00
P84RL	11/32 +.015	6 1/2	1 1/8	2	1 1/4			6.00
P85F	.370	6	7/8	2	3/4			3 1/4
P85L	3/8	7 1/4	7/8	2 1/4	3/4	1	3 1/4	6.00
P85RL	3/8 +.015	7 1/2	1 1/8	2 1/2	1 3/4			3 1/4
P97R	.397	5 7/8	7/8	2 1/8	5/8			3 1/8
P86RM	5/16 +.015	7 1/2	1	2 1/2	3/4	1	3 1/4	6.00
P86	5/16	6 1/4	1	2 1/2	3/4			5.50
P97	13/32	7 1/4	7/8	2 1/4	3/4	1	3 1/4	6.00

A complete listing of pilots is included in K. O. Lee Form SG-57.

Valve Guide Drivers

PRICE EACH \$2.00



No.	B	C	No.	B	C
G2250	.240	.430	G2344	11/32	.334
G2275	7MM	.265	G2375	3/8	.365
G2276	7MM	.265	G2376	3/8	.365
G2312	5/16	.302	G2397	.397	.388
G2313	5/16	.302	G2437	5/16	.427
G2343	11/32	.334	G2500	1/2	.490

Valve Guide Reamers

SOLID TYPE H1000 SERIES

Number	Size	Number	Size	Number	Size
H1236	6MM	H1334	8 1/2 MM	H1393	10MM
H1250	1/4"	H1343	11 1/32"	H1397	.397"
H1255	6 1/2 MM	H1353	11 3/32" + .010	H1406	13/32"
H1275	7MM	H1363	11 3/32" + .020	H1437	7/16"
H1281	9/32"	H1364	9MM	H1472	12MM
H1295	7 1/2 MM	H1373	3 3/8" — .002	H1500	1/2"
H1312	5/16"	H1374	9 1/2 MM	H1625	5/8"
H1315	8MM	H1375	3 3/8"		

GUIDE APPLICATION DATA

THE VALVE GUIDES LISTED ARE OUR "GL LEE-ALLOY" SERIES, MADE OF A DENSE LONGER WEARING ALLOY METAL. MOST OF THESE SIZES ARE ALSO AVAILABLE IN CAST IRON "G" SERIES. SEE LISTING ON PAGE 3.

Year	Model	Valve Intake	Guides Exhaust	Roughing Reamer	Finishing Reamer	Pilot Size	Pilot No.	Valve Guide Driver	Valve Guide Reamer	
BUICK										
1954-62	All Models Except Special	GL1372	GL1372	Not Req.	Not Req.	$\frac{3}{8}$	Not Req.	G2376	H1375	
BRIGGS AND STRATTON AND CLINTON										
1954-62	All Models $\frac{1}{4}$ " Stem No Factory Guide	GL1240	GL1240	H8432 $\frac{1}{4}$	H7437	$\frac{1}{4}$	P95L	G2250	H1250	
CHEVROLET										
1955-63	All V8 Pass. and Trucks; 265, 283, 327 Engines	GL1345	GL1340	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1958-62	All 348, 409 Engines	GL1376	GL1371	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	
1960-63	Corvair (Replaceable Guides)	GL1346	GL1346	Not Req.	Not Req.	$\frac{1}{2}$ $\frac{1}{2}$	Not Req.	G2343	H1343	
1962-63	Chevy II	GL1345	GL1345	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
CHRYSLER CORPORATION ENGINES										
1954-56	Plymouth, Dodge; 260, 270, 315, 325 Engines	GL1370	GL1370	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	
1956-62	Plymouth, Dodge, 277, 301, 318 Engines	GL1371	GL1376	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	
1958-62	Plymouth, Dodge, DeSoto, Chrysler; 350, 354, 361, 383, 413 Engines (D500-354 Takes GL1377)	GL1376	GL1376	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	
1956-58	Dodge, DeSoto; 325 Engine (D500)	GL1371	GL1371	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	
1960-63	Valiant and Lancer	GL1374	GL1374	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	
COMET AND FALCON										
1960-63	All Models; 144, 170 Engines	GL1310	GL1310	H8432 $\frac{1}{4}$	H7437	$\frac{5}{16}$	P83L	G2312	H1312	
FORD COMPANY ENGINES										
1954-62	6 Cyl. Pass. and Trucks; 223 Eng.; and 279 V8 Truck	GL1342	GL1342	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1954-55	V8 Passenger and Trucks; 239, 256 Engines	GL1340	GL1343	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1955-59	V8 Passenger and Trucks, 272, 292, 312 Engines	GL1340	GL1342	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1960-62	V8 Passenger and Trucks; 272, 292, 312 Engines	GL1342	GL1343	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1957-63	V8 Pass. and T-Bird, Merc.; 332, 352, 390, 406 Eng.	GL1373	GL1373	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1373	
1958-62	Thunderbird, Lincoln, Mercury; 383, 430 Engines	GL1375	GL1373	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1373	
1956-57	H. D. Truck with Sodium Valves; 272, 292 Engines EXHAUST	GL1345	GL1431	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1956-57	H. D. Truck with Sodium Valves; 302, 332 Engines	GL1340	GL1431	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1958-62	H. D. Truck with Sodium Valves; 302, 332 Engines EXHAUST	GL1373	GL1431	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1373	
1958-62	H. D. Truck with Sodium Valves; 401, 477, 534 Eng.	GL1430	GL1430	H8619 $\frac{1}{16}$	H7625	$\frac{1}{2}$ $\frac{1}{2}$	P86	G2437	H1437	
GMC TRUCKS										
1955-60	All V8 with 288, 316, 347 Engines	GL1344	GL1342	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1957-59	All V8 with 336 Engine	GL1340	GL1375	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1960-63	All V6 with 305 Engine	GL1344	GL1347	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1960-63	All V6 with 351, 401, 702 Engines	GL1377	GL1432	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	
	EXHAUST				H8619 $\frac{1}{16}$	H7625	$\frac{1}{2}$ $\frac{1}{2}$	P86	G2437	H1437
OLDSMOBILE										
1954-60	All Models (with Replaceable Guides)	GL1341	GL1390	Not Req.	Not Req.	Int. $\frac{1}{2}$ $\frac{1}{2}$ Exh. .397	Not Req.	G2344	H1343	
							Not Req.	G2397	H1397	
PONTIAC										
1955-60	All V8's	GL1342	GL1344	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1961-63	All V8's and 4 Cylinder Tempest	GL1345	GL1340	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
1963	421 H. O. Engine	GL1345	GL1345	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
RAMBLER										
1959-62	Aluminum OHV, 6 Cylinder	GL1345	GL1345	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{1}{2}$ $\frac{1}{2}$	P84L	G2343	H1343	
VOLKSWAGEN										
1953-60	All Models, 36 H.P. (Replaceable Guides)	GL1276	GL1276	Not Req.	Not Req.	7MM	Not Req.	G2275	H1275	
1960-63	All Models, 40 H.P. (Replaceable Guides)	GL1315	GL1315	Not Req.	Not Req.	8MM	Not Req.	G2312	H1315	
WISCONSIN										
	ACN, BKN, VH4, VE4, VF4, TE, TF	GL1310	GL1310	H8432 $\frac{1}{4}$	H7437	$\frac{5}{16}$	P83L	G2312	H1312	
	AGN, AHH, VG4D	GL1311	GL1311	H8432 $\frac{1}{4}$	H7437	$\frac{5}{16}$	P83L	G2312	H1312	
	VR4D, VQ4, VR4	GL1377	GL1377	H8494 $\frac{1}{2}$ $\frac{1}{2}$	H7500	$\frac{3}{8}$	P85L	G2375	H1375	

NOTE: H310G $\frac{1}{2}$ Round Drive and H310B $\frac{1}{2}$ Reaming Bushing are used with Roughing and Finishing Reamers. We recommend a $\frac{1}{2}$ " drill for power, as a power unit with about 400 R.P.M. is required. Roughing Reamer operation is followed with a Finishing Reamer. After Guide has been installed, our H1000 Series Solid Reamers as listed in extreme right column above, may be used to ream I.D. of Guide.